

Date: Monday, 7/9/2007 12:47:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK SADDLE
Job Number	: 33414		
Estimate Number	: 11177		
P.O. Number	: N/A	Part Number	: D2281
This Issue	: 7/9/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2281 REV G
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33258	Drawing Revision	: G
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 7/30/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	50 Um: Each
Comment	: Est Rev: A Removed from 9 Digit 05-12-02 JLM		
	: Est: rev B 06.07.17 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total: 6.5625 sf(s)

304SS .080

batch: M101873

M105412 -> SMO 07/08/03 (13) 5
 HB 07-07-21 (37)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

HB 07-07-21

SMO 07/08/03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Deburr

SMO 07/07/03 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/08/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:47:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 33414

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

8/3 07/08/07 (50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/07 (150)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11 07/08/07 (50)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

50 07/08/07

Job Completion



07-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33414
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.476	*			
4.114	+/-0.010	4.114	*			
2.933	+/-0.010	2.933	*			
1.535	+/-0.010	1.540	*			
0.354	+/-0.010	.354	*			
0.354	+/-0.010	.354	*			
0.604	+/-0.010	.604	*			
2.000	+/-0.010	2.000	*			
3.396	+/-0.010	3.396	*			
3.646	+/-0.010	3.646	*			
4.000	+/-0.010	4.006	*			
1.525	+/-0.010	1.529	*			
2.475	+/-0.010	2.477	*			
Ø0.323	+0.006/-0.001	Ø .322	*			
0.080	+/-0.010	.079	*			

Measured by:	RB	Audited by:	EW	Prototype Approval:	N/A
Date:	07-07-21	Date:	07/08/03	Date:	N/A

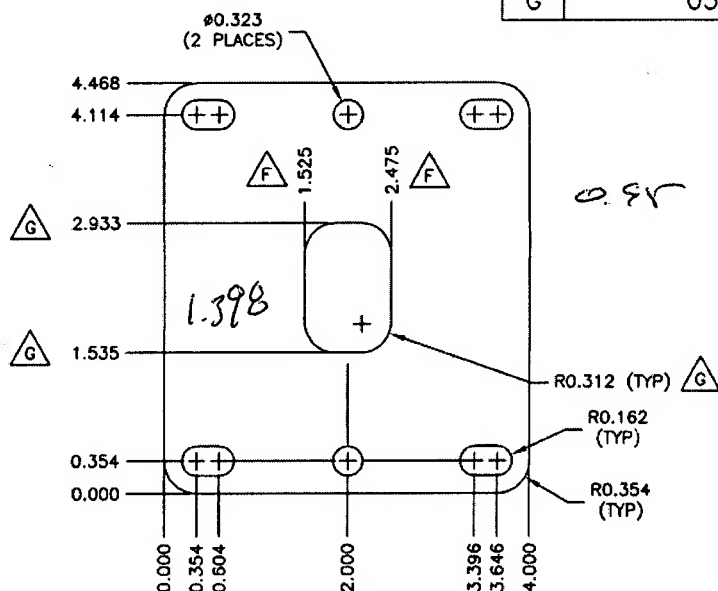
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]



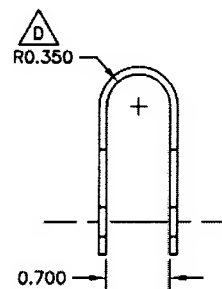
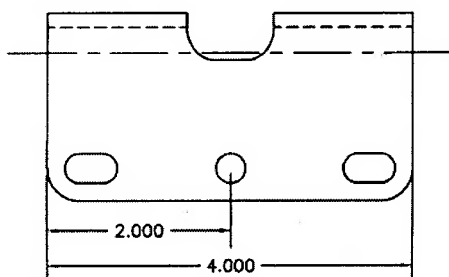
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE		SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED

05/08/11



FLAT LAYOUT



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WORK ORDER
NO. 33414

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